Work Order ID 120242

Wednesday, June 04, 2014 2:59:43 PM

120242

Item ID: D4634-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Fwd, Center Ceiling Panel

Start Date: 6/09/14 **Start Qty:** 1.00 *1*

Required Date: 6/09/14 **Req'd Qty:** 1.00 *1*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** MLS **Date:** 14-06-05 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr: D4634 / Revision Nbr: F									
100		0.00							DAS 07 9-89
100	HAND FINISHING THERMOFORMING					x1			
Thermoform	**Memo**	0.00							14/06/10
Thermoforming Machine	Cut Blanks								
105		0.00							DAS 07 9-89
105	Dry Material					x1			
HandThermo	**Memo**	0.00							14/06/10
Hand Finishing Thermoforming	Dry Sheet as per QSI022 POLYCARBONATE								

Temp: ~~245 deg. F~~

Time IN: 5:00 PM

Time OUT: ~~6:00 AM~~

JUN 10 2014

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Item ID: D4634-1 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Fwd, Center Ceiling Panel

Start Date: 6/09/14 **Start Qty:** 1.00 *1*
Required Date: 6/09/14 **Req'd Qty:** 1.00 *1*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							DAS 07 9-89
110	THERMOFORMING MACHINE					x1			
Thermoform	**Memo**	0.00							14/06/13
Thermoforming Machine	Thermoform as per Dwg. D4634-1 and Folio FTA144								
	Dwg. Rev. E								
	Folio Rev. E								
	NOTE: Check moulds prior to using to ensure proper placement of add-ons.								
	Visually inspect for proper formation and texture								
130		0.00							
130	HAND FINISHING THERMOFORMING					x1			JB 14/06/13
Thermoform	**Memo**	0.00							
Thermoforming Machine	Trim to Finished Dimensions								

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

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☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Item ID: D4634-1 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Fwd, Center Ceiling Panel
Start Date: 6/09/14 **Start Qty:** 1.00 *1* **Cust Item ID:**
Required Date: 6/09/14 **Req'd Qty:** 1.00 *1* **Customer:**
Reference:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	~~QC6~~ QC5- Inspect dimensions to drawing	0.00							
140	Dimensional Inspection								
QC	**Memo**	0.00	DAS 16 9-89 14/06/25						
Quality Control	Fill in Inspection Sheet Rev A								
150	~~QC5~~ QC6- Inspect part completeness to step on W/O 14/06/25	0.00							
150									
QC	**Memo**	0.00							
Quality Control									
160		0.00							
160	Packaging								
Packaging	**Memo** Section: MF	0.00				(1) SAD 14/06/25			
Packaging									

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
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- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
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- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Item ID: D4634-1 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Fwd, Center Ceiling Panel

Start Date: 6/09/14 **Start Qty:** 1.00 *1* **Cust Item ID:**
Required Date: 6/09/14 **Req'd Qty:** 1.00 *1* **Customer:**
Reference:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21- Final Inspection - Work Order Release	0.00							
170						MLJ	14-06-25		
QC	**Memo**	0.00							
Quality Control									

MF 14-6-25

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

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Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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Landing Gear

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☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
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General

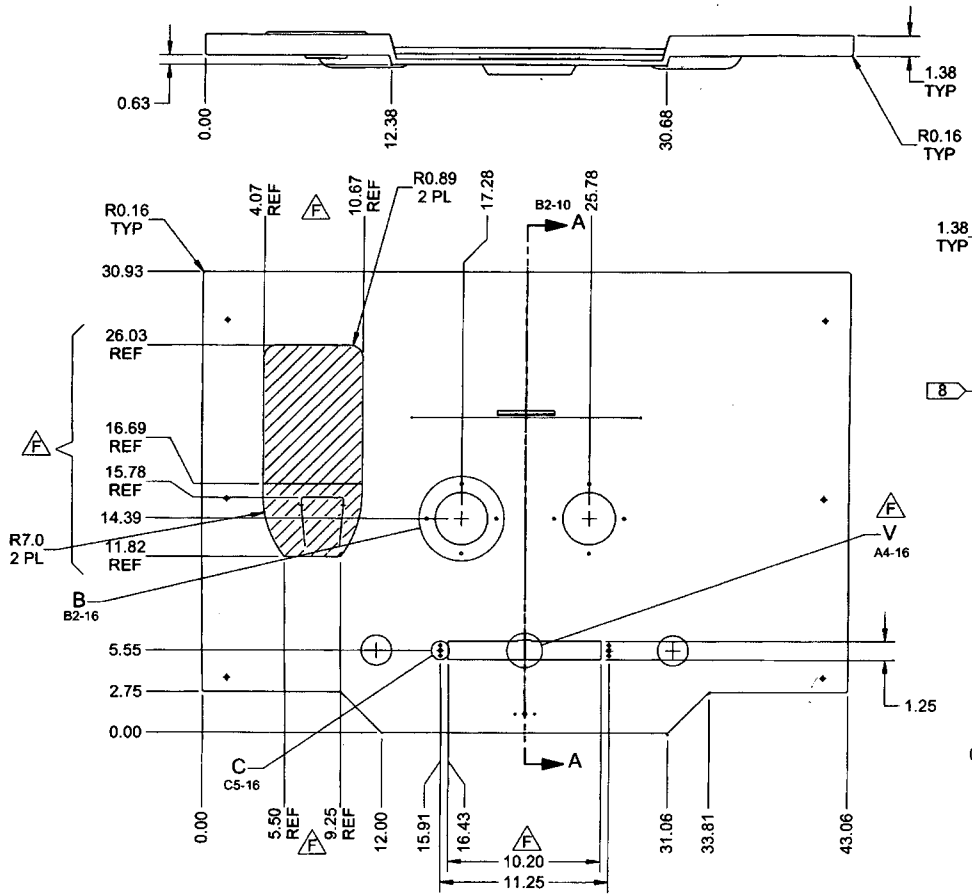
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☐ Drill Holes
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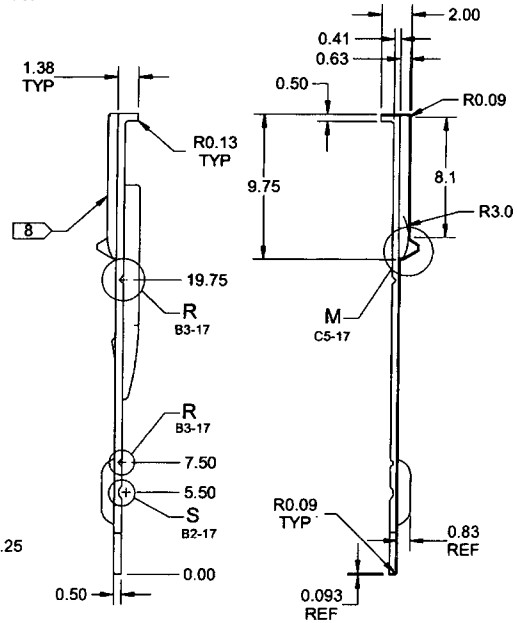
☐ Folio/Program
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☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other





SECTION A-A C6-10

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 120242 MLS

14-06-05

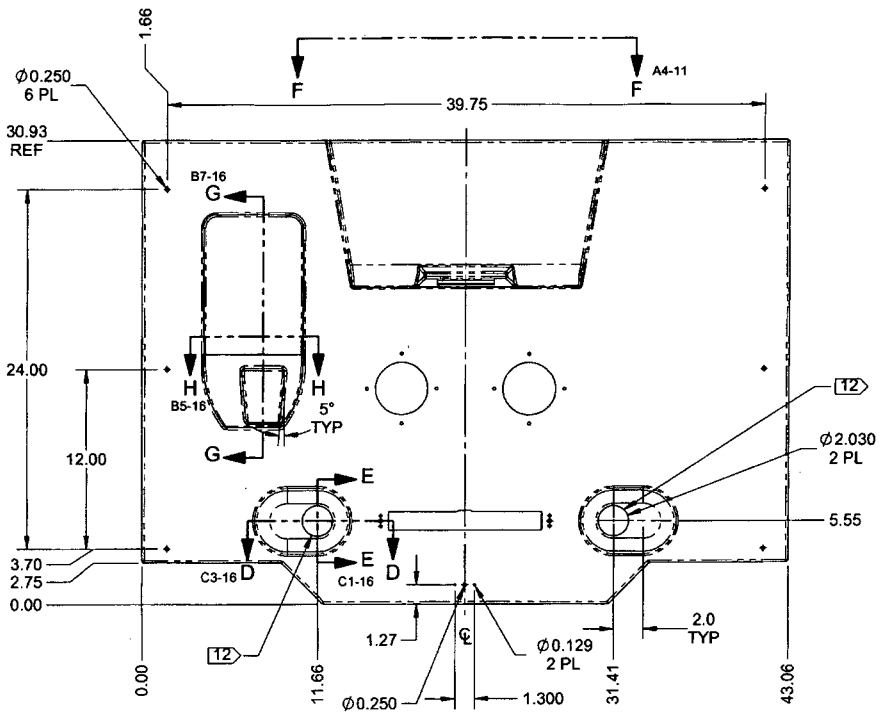
NOTES:
1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 5.65 lbs
8) TEXTURE ON THIS SIDE
9) 0.14 RADIUS NOT SHOWN FOR CLARITY
10) DRILL & TRIM D4634-1 PER TOOL DT9836
11) THERMOFORM PER QSI 022 USING DT9844 TOOL
MIN. THICKNESS AFTER FORMING:
SHADED AREA = 0.020
EDGES = 0.060
ELSEWHERE = 0.070
12) LOCATE ∅2.030 AT CENTER OF PROTRUDED SURFACE AS SHOWN

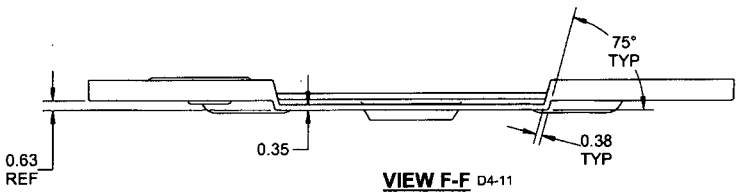
D4634-1 FWD, CENTER CEILING PANEL

RELEASED
2014 FEB 25

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	DC	DRAWING NO. D4634 REV. F
MFG. APPR.		SHEET 10 OF 17
APPROVED		TITLE CENTER CEILING PANELS SCALE NTS
DE APPR.		
DATE	14.02.03	

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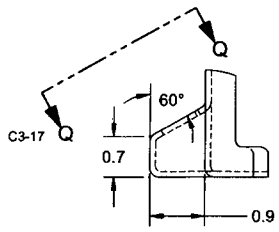
VIEW F-F D4-11

D4634-1 FWD. CENTER CEILING PANEL
AUXILIARY VIEW

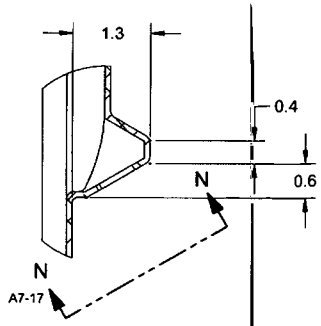
RELEASED
2014 FEB 25

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	DRAWING NO. REV. F
CHECKED		D4634 SHEET 11 OF 17
MFG. APPR.		TITLE SCALE
APPROVED		CENTER CEILING PANELS NTS
DE APPR.		
DATE	14.02.03	

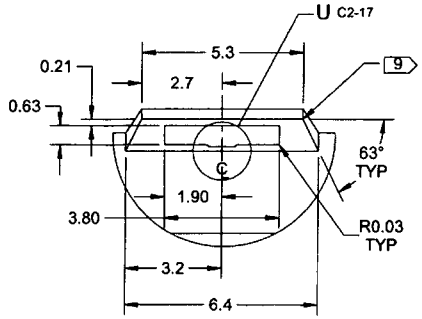
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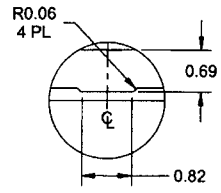
DETAIL P B3-14
SCALE 2X



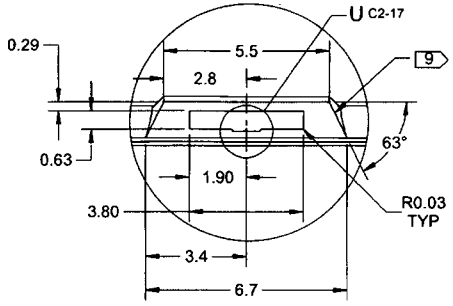
DETAIL M C3-10
SCALE 2X



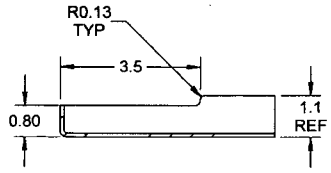
DETAIL Q B4-15 D8-17
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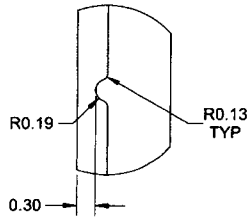
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SCALE 0.5X



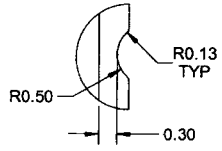
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SCALE 0.5X



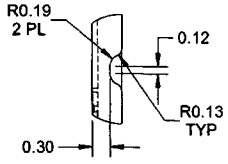
SECTION O-O B6-14
SCALE 1.3X



DETAIL R B3-10 C3-10 B2-12
SCALE 4X



DETAIL S B3-10 C2-12
SCALE 4X



DETAIL T C2-14
SCALE 4X

RELEASED
2014 FEB 25

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	DC	DRAWING NO. D4634 REV. F
MFG. APPR.		SHEET 17 OF 17
APPROVED		TITLE CENTER CEILING PANELS SCALE NTS
DE APPR.		
DATE	14.02.03	

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DART AEROSPACE LTD

Description: Fwd Center Ceiling Panel		**Work Order:** 120242
Inspection Drawing: 4634-1	**Rev:** F	**Part Number:** D4634-1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.00	+/-0.030	12.00	✓		M-T	STAB-21
24.00	+/-0.030	24.00	✓		↓	↓
39.75	+/-0.030	39.75	✓			
11.66	+/-0.030	11.66	✓			
31.41	+/-0.030	31.41	✓		↓	↓
1.300	+/-0.010	1.300	✓		Vern	STAB-03
Ø0.250	+0.005 -0.001	Ø0.250	✓			
Ø2.030	+0.002 -0.001	Ø2.030	✓			
4.667	+/-0.010	4.667	✓			
2.334	+/-0.010	2.334	✓			
Ø3.50	+/-0.010	Ø3.50	✓			
Ø0.191	+/-0.005 -0.001	Ø0.191	✓			
3.80	+/-0.030	3.80	✓			
0.63	+/-0.030	0.63	✓		↓	↓
1.25	+/-0.030	1.25	✓		Vern	"
10.20	+/-0.030	10.20	✓		M-T	STAB-21
11.25	+/-0.030	11.25	✓		M-T	"

Measured by: SAM	**Checked By:** DAS 16 9-89	**QC inspector:** DAS 16 9-89	**Engineering Approval** *(if necessary)*:
Date 14/06/24	**Date** 14/6/25	**Date** 14/6/25	**Date**